

Work Order ID 59762

Thursday, June 10, 2010 2:45:09 PM



Page 1

Item ID: D130-780-011

Accept



Setup Start



Revision ID:

Item Name: Aft LH Door Hinge

Stop



Start Date: 6/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *K* Date: 10-6-10 Tooling: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
DSI 9502	A
IIN-D130-780	B

100 0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D130-780-011
CHG 003

S 10/06/30

K for BG 10/06/30

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

10-6-30 (2x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 6/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

8/10/09/10

2

QC

Quality Control

130



Packaging

Packaging

Memo

0.00

Memo

0.00

Identify and pack for shipping as per PPP D130-780-011

Location: 10PPP rev: C

10-6 30SF 2x

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/01 4J
C2 10/711

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Picklist Print

Thursday, June 10, 2010 2:45:13 PM

Page 1

Work Order ID: 59762



Parent Item: D130-780-011



Parent Item Name: Aft LH Door Hinge

Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D130-780-015		Manufactured	No			110	Each	4.0000	1	2		10-6-30 S	

62 Closeout Installation CTG702

Location

FG 4

56838 4

110 Each 7.0000 1

D3552-13

Manufactured No

Location

ST272A 7

56392 7

110 Each 97.0000 1

D3892-1

Manufactured No

Location

ST416 97

47330 97

110 Each 4.0000 1

cut to 5"

D3813-041

Manufactured No

Location

ST090 4

53043 4

110 Each 4.0000 1

60 Hinge Assembly, Upper Door

10-6-30 S

2 10-6-30 S

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3813-043		Manufactured	No			110	Each	2.0000	1	2		10-6-30	SI



Hinge Assembly, Lower Door

Location

ST090 2

53044 2

110 Each 8.0000

Loc Qty

Loc Code

10-6-30

D3814-1



Manufactured No

Location

ST091 8

50119 2

50261 6

110 Each 14.0000

Loc Qty

Loc Code

10-6-30

D3814-3



Manufactured No

Location

ST091 14

50120 2

50475 12

110 Each 12.0000

Loc Qty

Loc Code

10-6-30

D3816-1



Manufactured No

Location

ST091 12

45675 12

110 Each

Loc Qty

Loc Code

10-6-30

W/O:		WORK ORDER CHANGES						
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IPP Rev:B as

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Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3816-3		Manufactured	No			110	Each	8.0000	4	8		10-6-30 sf	



Spacer

Location

ST091 8

52930 8

110 Each 17.0000



10-6-30 sf

D3817-041

Manufactured

No

Location

ST092 17

50381 17

110 Each 817.0000



10-6-30 sf

AN3-5A

Purchased

No

Location

ST350 817

105057 817

110 Each 133.0000



10-6-30 sf

AN3-7A

Purchased

No

Location

ST351 133

113539 14

114227 19

114784 100



10-6-30 sf

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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4		Purchased	No			110	Each	29.0000	2	4		10-6-30	



NUT

Location

ST324 26

114716 26

ST349 3

114341 3

110 Each 50.0000



AN4-17



BOLT

Purchased No

Location

ST359 50

113121 20

113288 30

110 Each 97.0000



AN970-4



Washer

Purchased No

Location

ST349 97

112991 97

110 Each 97.0000



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Required Date: 6/25/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L3		Purchased	No			110	Each	3,282.000	5	10		10-6-30	



Location	Loc Qty	Loc Code
ST300	3282	
113537	18	
113644	3	
114523	761	
114718	500	10
114784	2000	

MS24665-2-12

Purchased

No

110

Each

111.0000

2

4

10-6-30



Location	Loc Qty	Loc Code
ST309	111	
111499	111	

MS24694-S46

Purchased

No

110

Each

76.0000

3

4

10-6-30



Location	Loc Qty	Loc Code
ST289	76	
111499	76	

6

10-6-30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 6/10/2010

Required Date: 6/25/2010

Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty Otv	Qty Issued	Date Issued	Status
NAS1149D0363J						110	Each	785.0000	8	16		10-6-30	SP

EW Washer

Location

Location	Loc Qty	Loc Code
ST298	785	
113288	2	
114292	183	
114884	600	

NAS1149D0463J

Purchased

No

Location

Location	Loc Qty	Loc Code
ST298	1256	
114576	756	
114883	500	

D3622-1

Manufactured

No

Ball Stud

Location

Location	Loc Qty	Loc Code
ST074	13	
55199	13	

D3820-1

Manufactured

No

Bracket

Location

Location	Loc Qty	Loc Code
ST092	20	
42079	1	
45732	19	

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Comments: IPP Rev:A 09-02-03 new issue DD verified by:JLM
per DSI 9502 revA DD 10.02.17 verified by:EC

IPP Rev:B as

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch Purchased	Bin Item No	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21042L5						110	Each	726.0000	2	4			



S2
Nut

Location

ST139	500	
114813	500	
ST300	226	
114449	226	

Loc Qty

Loc Code

15-6-30

NAS1149D0563J

Purchased

No

4

Washer

Location

ST298	3642	
113524	2	
113706	640	
114742	3000	

Loc Qty

Loc Code

15-6-30



8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1			X				D130-780-011	LH SLIDING DOOR HINGE KIT
1	1			X			D130-780-013	SWITCH RELOCATION KIT
				,1~		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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NOTE: Date & initial all entries

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2			D3819-1	MALE SPADE CONNECTOR
				2			D3597-1	FEMALE SPADE CONNECTOR
				1			D3598-2-096	EXPANDABLE SLEEVE
				24			D3599-1	TIE-WRAP
				24			D3600-1	TIE-WRAP MOUNT
				24 FT			M22759/41-22-9	WIRE
		1*	1*	1			D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
1**		1*					D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES							
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NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

S
IIN-D130-780

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-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
					1		D3983-1	OUTER CLOSEOUT
					1		D3983-3	INNER CLOSEOUT
					1		D3983-5	HINGE CLOSEOUT
					1		D3983-047	CLOSEOUT ATTACHMENT
					1		D3983-9	SPACER
					2		AN525-10R6	SCREW
					1		AN525-10R24	SCREW
					1		NAS1149D0363J	WASHER
					1		MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries